

# Work Order ID 71118

Thursday, June 23, 2011 11:04:15 AM



Page 1

Item ID: D3172-041

Accept



Setup Start



Revision ID:

Item Name: Basket Base Assembly

Stop



Start Date: 6/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date: 11/06/23

Tooling:

Date:

Run Start



QC: *[Signature]*

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3172

Rev C

100

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1-Cut Qty 4 D3166-1 as per Dwg D3172  
2-Cut 3/4" x 3/4" square tubing as per Dwg D3172  
3-Drill holes in D3172-3 as per Dwg D3172  
4-Deburr & Remove all markings from material  
5-Weld as per Dwg D3172 using Welding Table and corner Jig & D3172T1  
6- Use DT 8996 jig to locate D3174-1 as per dwg  
7- Deburr

*11.10.27*

*(14) 0*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Quality Control

Memo

0.00

*BE 11.10.27*

*1 0*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71118

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Page 2

Item ID: D3172-041

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Revision ID:

Stop



Item Name: Basket Base Assembly

Start Date: 6/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00  0.00		5 u/10/177					
125  HandFinish Hand Finishing	Pressure Wash per QS1005 4.3  Memo	0.00  0.00							6/24/03

**Dart Aerospace Ltd**

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**NOTE:** Date & initial all entries

\_\_\_\_\_

Page 3

[illegible]

**Stop**

**Abstract**

\_\_\_\_\_

**Reference:**

**Stop**

Date:

**Insp.  
Stamp**

0.00

\_\_\_\_\_

## Powdercoat

## Powder Coating

## Memo

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*\*\*2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

140

### QC3- Inspect Part Finish

0.00

\_\_\_\_\_

QC

## Quality Control

## Memo

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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**Work Order ID 71118**

Thursday, June 23, 2011 11:04:15 AM



Page 4

Item ID: D3172-041

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Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly

Start Date: 6/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: W/O

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

D130-701-043 / B71112 1 of 11 u/u/a

11/11/8

me 11-11-07

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, June 23, 2011 11:04:12 AM

Page 1

Work Order ID: 71118

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly



Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 04.01.05 Added Step 5 inspection KJ/RF  
IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC  
11.04.04 added pressure wash DD VERF:EC  
IPP Rev:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2012-117		Manufactured	No			100	Each	43.0000	2	2			
Clevis													

Location	Loc Qty	Loc Code
WA	31	
69890	31	
WA005	12	
55729	12	

* D2232-3		Manufactured	No			100	Each	6.0000	2	2			
Basket Hinge													

Location	Loc Qty	Loc Code
WA005	6	
69211	6	

✓ D2327-3		Manufactured	No			100	Each	26.0000	2	2			
Spacer Bushing													

Location	Loc Qty	Loc Code
WA	20	
70884	20	
WA005	6	
70724	6	

PL 11.10.25

⊖

PL 11.10.25

B72929 → ①

B75581 → ①

PL 11.10.25

B72963 → ②

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, June 23, 2011 11:04:12 AM

Work Order ID: 71118

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly

Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2581



Mounting Bracket

Manufactured No

100

Each

105.0000

2

2



Location

Loc Qty

Loc Code

WA

105

68964

4

69258

28

69739

22

70766

51

*Pl 11.10.25*  
~~B73762~~ → (2)  
~~B73079~~ → (2)

D3166-1



Basket Hoop

Manufactured No

100

Each

10.0000

4

4



Location

Loc Qty

Loc Code

WA

10

70188

10

*Pl 11.10.19*  
~~B73078~~ → (3)  
~~B72589~~ → (1)

D3174-1



Mounting Lug

Manufactured No

100

Each

18.0000

8

8



Location

Loc Qty

Loc Code

WA

18

69935

18

*Pl 11.10.25*  
 (2)  
~~B71272~~ → (6)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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	3							

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 23, 2011 11:04:12 AM

Work Order ID: 71118

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly

Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

479.0034

48

48



Expanded Metal Flat SS

Location

Loc Qty

Loc Code

MAT

38.2107

117708

38.2107

WA

440.7927

115012

95

117197

102.9036

117455

16.0341

117896

226.855



*Cpl 11-10-24*

*M119180 → 48*

M304TS0.750W.065

Purchased

No

100

f

565.5786

51

53.68421



304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT018

451.7236

117598

374.0249

117636

77.6987

WA007

113.8549906

116267

99.549272

116763

14.3057186



*M118773 → 53.642*  
*Cpl 11-09-27*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

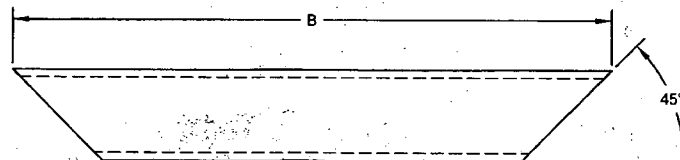
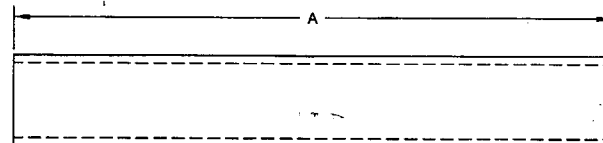
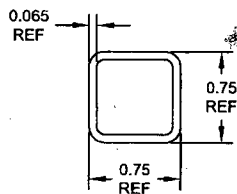
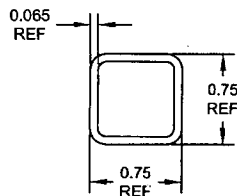
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NOTE: Date & initial all entries

# **PARTS LIST FOR D3172-041 BASKET BASE ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.09	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	N/A	RIB
D2012-117	4	N/A	N/A	CLEVIS
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG



**RELEASED**  
08-05-21/12

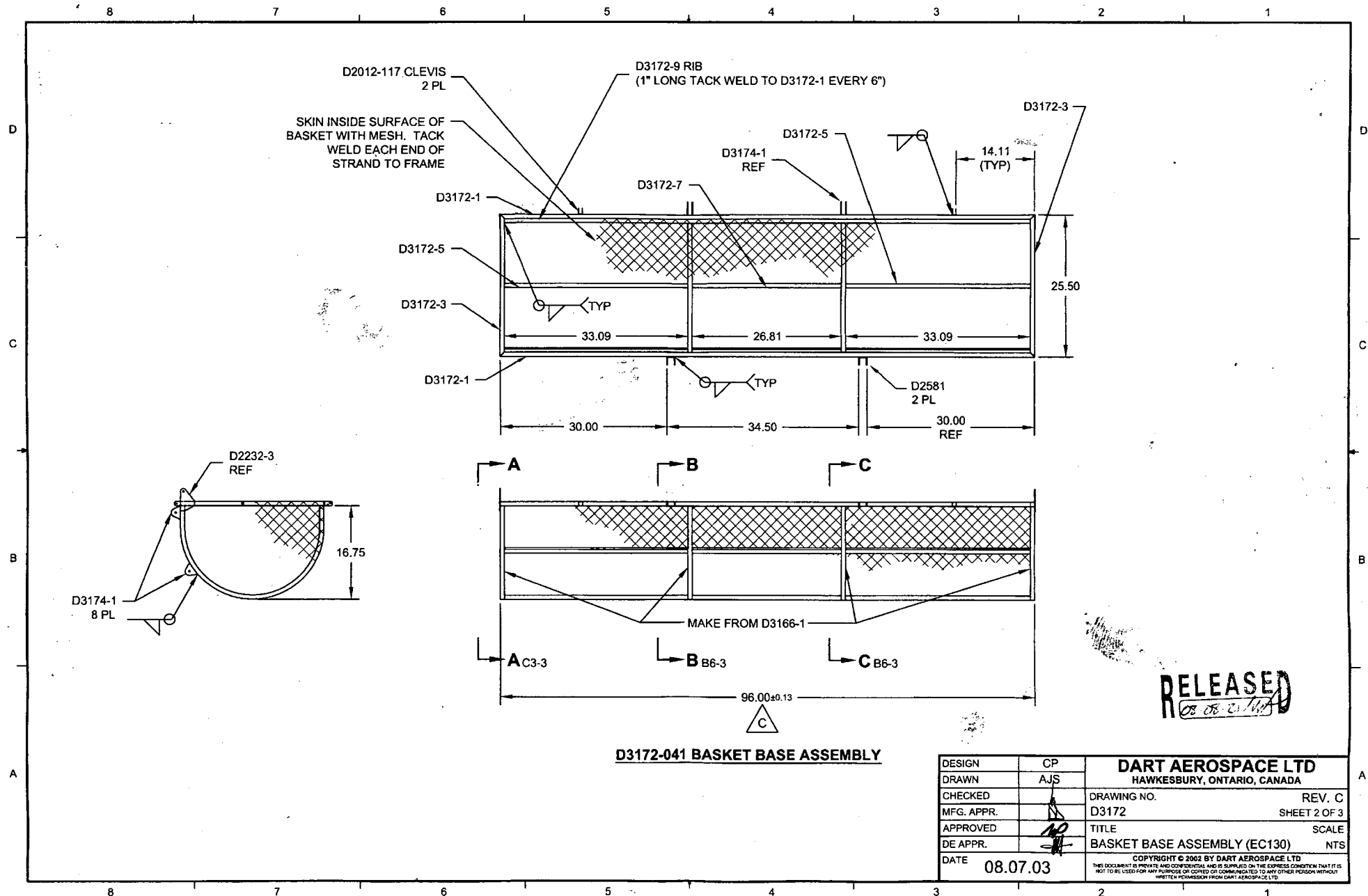


## **NOTES:**

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71118

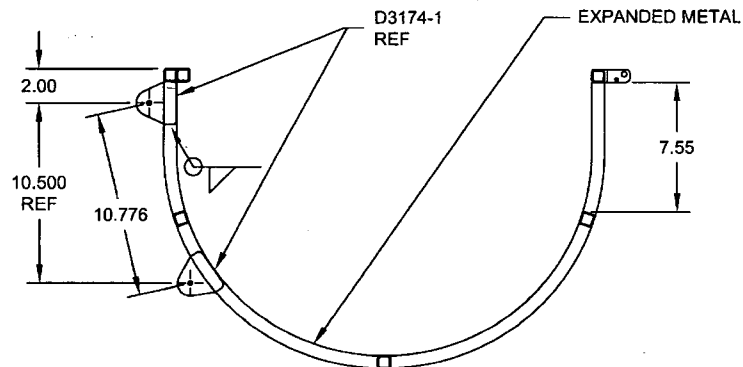
C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.03
B	ADD D3172-9 & D2012-117	CP	03.01.07
A	NEW ISSUE	DS	02.12.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3172	SHEET 1 OF 3
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET BASE ASSEMBLY (EC130)	NTS
DATE	08.07.03	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



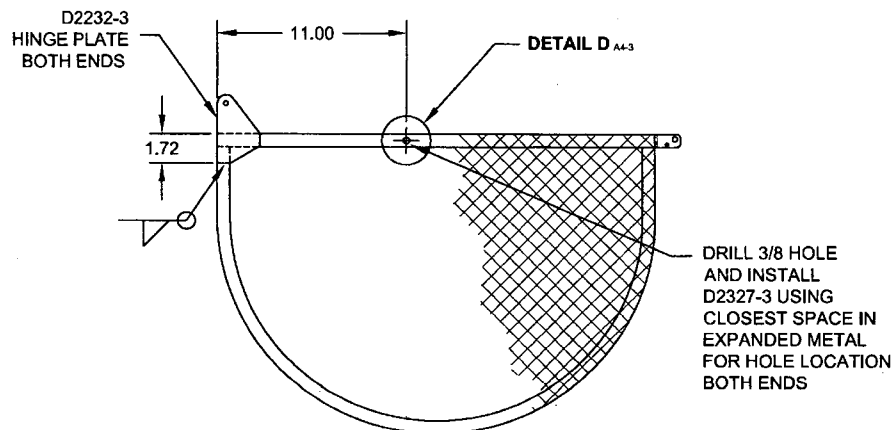


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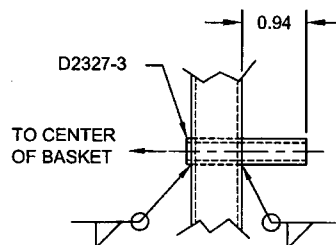
D



**SECTION B-B<sup>B5-2</sup>  
AND SECTION C-C<sup>B3-2</sup>**  
RIB DETAIL  
SCALE 2X



**SECTION A-A<sup>B5-2</sup>**  
SPACER DETAIL  
SCALE 2X



**DETAIL D<sup>D3-3</sup>**  
SCALE 4X

**RELEASED**  
08.08.21/1140

B

A

8 7 6 5 4 3 2 1

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3172	REV. C SHEET 3 OF 3
MFG. APPR.		TITLE BASKET BASE ASSEMBLY (EC130)	SCALE NTS
DE APPR.		COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.07.03		